

729-011

Dart Aerospace Ltd.

Date: Friday, 23/01/2009 8:49:05 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW MEDIUM BELL
Job Number	: 45202A		
Estimate Number	: 12129		
P.O. Number	:	Part Number	: D412729041
This Issue	: 23/01/2009 S.O. No. :	Drawing Number	: DSK 092 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 45201A	Material	:
Written By	:	Due Date	: 06/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>729-01-23</u>		
Comment	: Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

N/A

2.0	D27287	Dart Logo label
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Comment: Qty.: 0.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label 322554

Pl 09-05-19

3.0	D3233041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly

347494

Pl 09-05-19

4.0	D32331	Inside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer

625
343865-1
347798-3

Pl 09-05-19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: GHW MEDIUM BELL

Job Number: 45202A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0 D32333 Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer B45170

Plc 09.05.19

✓ 6.0 D33091 Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label B43659

Plc 09.05.19

✓ 7.0 D33093 Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label B45273 (3)

B45173 (1)

Plc 09.05.19

✓ 8.0 D3330041 Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment B47511

Plc 09.05.19

✓ 9.0 D3331041 Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly B47512

Plc 09.05.19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45202A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B44202

Pl 09.05.19

✓ 11.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly B44366

Pl 09.05.19

✓ 12.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B43448
3

Pl 09.05.19

✓ 13.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate B45082 (3)
B47468 (1)

Pl 09.05.19

✓ 14.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail B47469

Pl 09.05.19

W/O:		WORK ORDER CHANGES					
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Job Number: 45202A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B46043

Pl 09-05-19

✓ 16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B47513

Pl 09-05-19

✓ 17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B43450

Pl 09-05-19

✓ 18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B47515

Pl 09-05-19

✓ 19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer M110363

Pl 09-05-19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: GHW MEDIUM BELL

Job Number: 45202A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 20.0 CP21 1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span

M108200

Lpl 09.05.19

21.0 HC12 1/4"-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

N/A Lpl 09.05.19

✓ 22.0 HC29 5/16"-18 UNC x 1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M110684 → 19
M110759 → 13

Lpl 09.05.19

✓ 23.0 HC153 3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span

M110611

Lpl 09.05.19

✓ 24.0 HN120 HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof M102150

Lpl 09.05.19

D3015-1 Lock Nut → B14710

Lpl 09.05.19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45202A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span

M110611

Pl 09-05-19

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M108200

Pl 09-05-19

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

~~M110450~~
M109840

Pl 09-05-19

28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

M102150

Pl 09-05-19

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M111690

Pl 09-05-19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M110611

lpl 09-05-19

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof M107762

lpl 09-05-19

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

lpl 09-05-19

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 01/05/19 (x2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PDP 45002

lpl 9/5/20 (2)

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

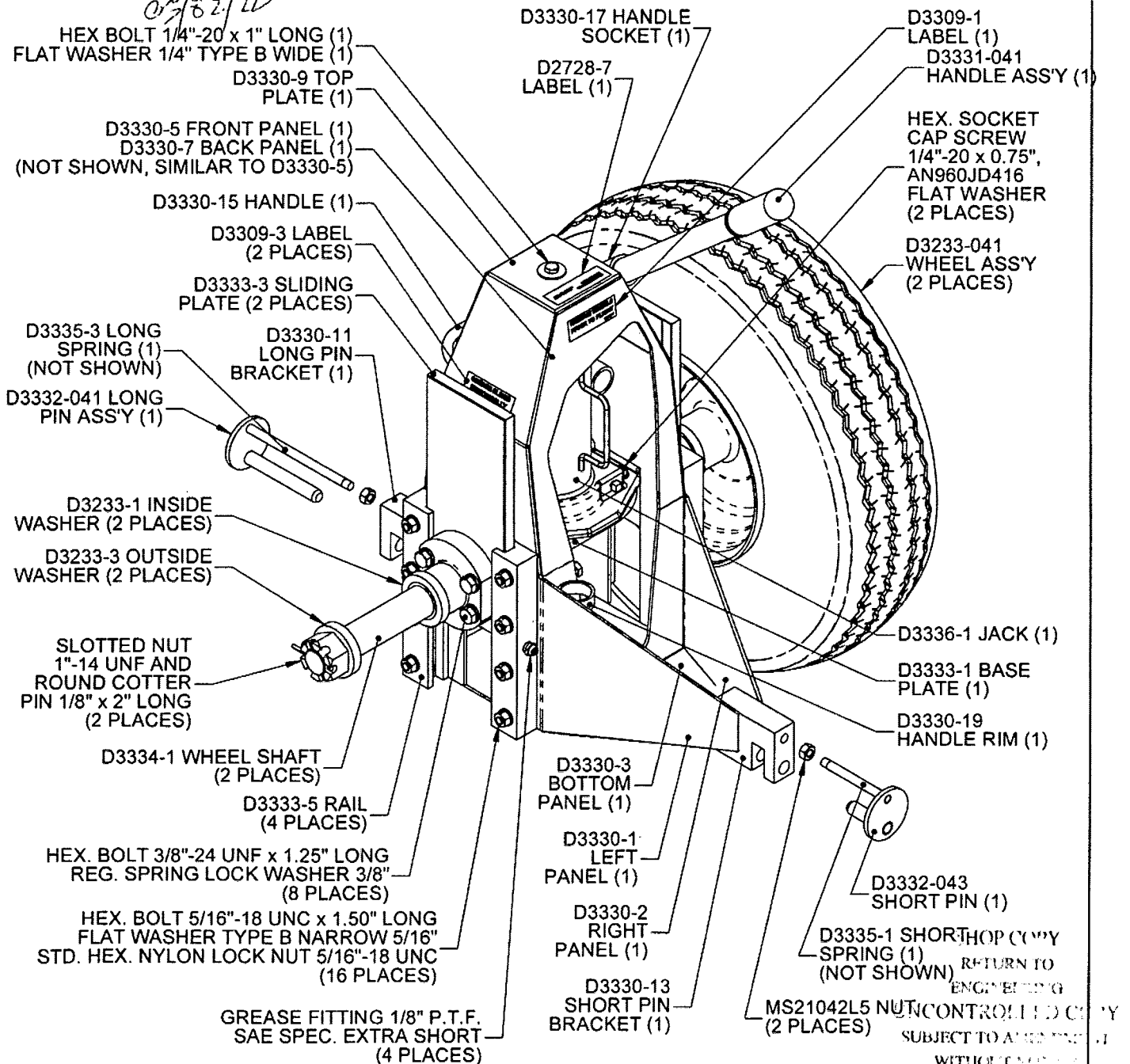
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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASSY	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
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